

205.633.011

Dart Aerospace Ltd.

22

Date: Wednesday, 5/16/2007 1:29:06 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT
 Job Number : 32389A
 Estimate Number : 10176
 P.O. Number : N/A Part Number : D2563
 This Issue : 5/16/2007 S.O. No. : N/A Drawing Number : D2563 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : C
 Previous Run : 32382A Material : N/A
 Written By : Due Date : 5/30/2007 Qty: 8
 Checked & Approved By : 07.05.16 10 Um: Each
 Comment : Est Rev:G 02.07.31 Re-format Location RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2244116 Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

1 D2244 Step Extrusion

Batch: 0282160.1m 07.04.22

10

2.0 D267334 End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part No.	Description	Batch
2	D2673-34	End Cap	<u>332404</u>

Batch

332404

3.0 D2561 Lug Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part No.	Description	Batch
2	D2561	Lug Plate	<u>330384 = 16</u>

Batch

330384 = 16

4.0 D2564 Mounting Angle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part No.	Description	Batch
2	D2564	Mounting Angle	<u>330464</u>

Batch

330464

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:29:06 PM
User: Kim Johnston

Ship 06/07 Friday
Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 32389A

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 89.70" at 34° as per Dwg D2563

Q.M. 07.06.22

2-Deburr ends

J.E. 07.06.25

3-Weld (1 End CAP,LUG PLATES & MOUNTING ANGLE as per Dwg D2563 using DT 8343

A/R AL ROD

Batch:

M102756

M104304

J.E. 07.06.26

4-Grind

Q.M.

07.06.26

6.0

QC5/9

WELD INSPECTION



Q15-707062710



Comment: WELD INSPECTION

PD 07.06.27

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.M.

07.06.28

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

J.E. 07.07.03

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

2-Weld Remainig End as per Dwg D2563 using DT 8343

A/R AL ROD

Batch:

M102756

M104721

J.E. 07.07.03

J.E. 07.07.03

3-Grind

Q.M.

07.07.04

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/07/04 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 2 Date: 8/10/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:29:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 32389A

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

27-07-04 (10)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine then

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 104144

BR/M/L 07-07-05

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

M/L/E

07/07/05 (10)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PPP 32945

6/17/05

(10)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/05

(8)

Job Completion



U 07-07-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

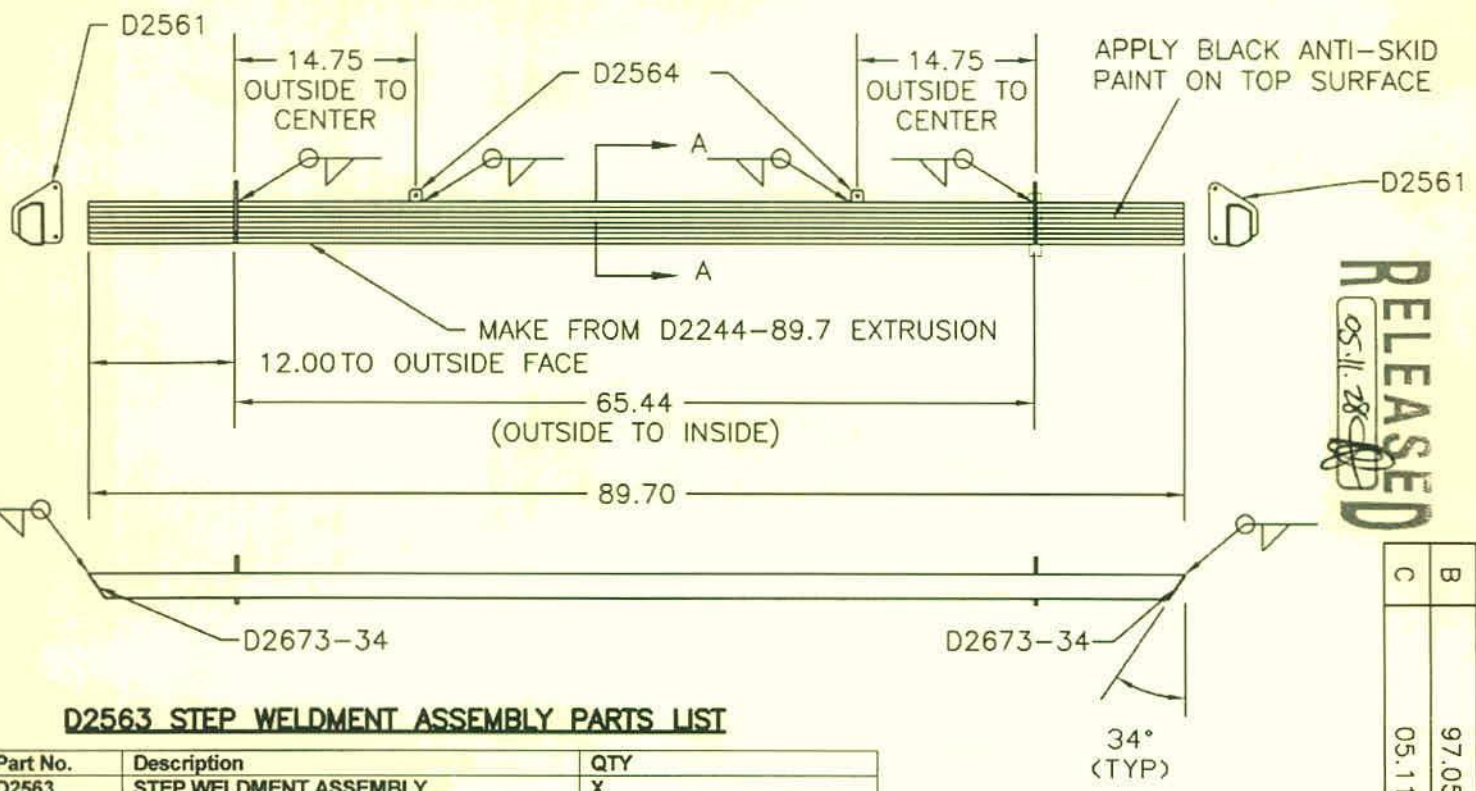
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
05.11.28

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	44	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
05.11.14	05.11.14	D2563
DATE	TITLE	SHEET 1 OF 1
05.11.14	STEP WELDMENT ASSEMBLY	SCALE 1:15
A	NEW ISSUE	
B	END CAPS CHANGED (WAS D2248)	
C	UPDATE NOTES	



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

cut per drawing
WORK ORDER
32389A
CONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
WITHOUT NOTICE
SUBJECT TO AMENDMENT

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

